



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4463-041
Job Sheet 180678



Part No: D4463-041

Job Qty: 2 ea

Part Name: Tank Top Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 8/3/18 *31 July*
Type: SOLD

Created By: Marie Lajeunesse

Description:

Note: DWG REV D SHEETS 1,2 IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER
DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Waterjet		<i>SC 8/18/18</i>
100	Waterjet	2 pcs	8/3/18	8/3/18	0.01	0.79	Waterjet1		<i>SC 8/18/18</i>
110	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC2 Waterjet-3		<i>SC 8/18/18</i>
120	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC8-4		<i>38</i>
130	Small Fab	2 pcs	8/3/18	8/3/18	0.00	0.75	Small Fab-6		<i>9-89 DAS 38</i>
140	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC5		<i>DR 18/08/18</i>
150	HandFinish	2 pcs	8/3/18	8/3/18	0.00	0.32	HandFinish1		<i>AUG 2 9 2018 68</i>
160	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC7-3		<i>DAS 9-89</i>
170	Small Fab	2 pcs	8/3/18	8/3/18	0.00	0.75	Small Fab-6		<i>SC 18/08/18</i>
180	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC5		<i>9-89</i>
190	Packaging	2 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-2		<i>DAS 21 SEP 11 2018</i>
200	QC21-SA	2 Ea	8/3/18	8/3/18	0.00	0.00	QC21		<i>9-89</i>

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	7.7280 sf (3.864 ea)	90-Start up Operation	
MS20426AD3-4	Rivet	96 Ea (48 ea)	170-Small Fab	<i>F/M 36444-2</i>
NAS1473R3	Anchor Nut	48 Ea (24 ea)	170-Small Fab	<i>5095403</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	8	287	0
170-Small Fab	MS20426AD3-4	96	3,224	0
	NAS1473R3	48	36	0

Part Specifications

Specifications could not be found.

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
NCR No. _____		Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
		Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
		Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval			
Description Work Order Deviation											
 Container No: S102084 Part: D4463-041 Job No: 180678 Serial No/Batch: S102084 Revision: _____ Inspector: _____ Exp. Date: _____ Instructions: Various STC's											
 Container No: S102084 Part: D4463-041 Job No: 180678 Serial No/Batch: S102084 Revision: _____ Inspector: _____ Exp. Date: _____ Instructions: Various STC's											
 Part: D4463-041 Job No: 180678 Serial No/Batch: S102084 Revision: _____ Inspector: _____ Exp. Date: _____ Instructions: Various STC's											
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DART AEROSPACE LTD		Work Order:	180678
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463	Rev: D	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.099	1		VSC-01	
Ø0.206	+0.005/-0.001	Ø0.207	1		Tape	
Ø1.00	+0.012/-0.001	Ø1.00	1			
1.15	+/-0.030	1.155	1			
1.85	+/-0.030	1.856	1			
2.20	+/-0.030	2.201	1			
2.30	+/-0.030	2.302	1			
5.29	+/-0.030	5.296	1			
8.30	+/-0.030	8.304	1			
8.93	+/-0.030	8.935	1			
8.98	+/-0.030	8.988	1			
9.31	+/-0.030	9.316	1			
10.42	+/-0.030	10.426	1			
11.26	+/-0.030	11.264	1			
1.61	+/-0.030	1.615	1			
1.68	+/-0.030	1.687	1			
1.82	+/-0.030	1.822	1			
3.41	+/-0.030	3.414	1			
3.79	+/-0.030	3.80	1			
6.43	+/-0.030	6.434	1			
7.36	+/-0.030	7.367	1			
7.80	+/-0.030	7.803	1			
10.75	+/-0.030	10.75	1			
11.38	+/-0.030	11.38	1			
11.80	+/-0.030	11.80	1			
13.27	+/-0.030	13.27	1			
1.15	+/-0.030	1.15	1			
3.00	+/-0.030	3.00	1			
3.26	+/-0.030	3.266	1			
7.00	+/-0.030	7.00	1			
10.74	+/-0.030	10.74	1			
11.00	+/-0.030	11.00	1			
11.63	+/-0.030	11.63	1			
15.29	+/-0.030	15.29	1			
15.48	+/-0.030	15.49	1			
19.48	+/-0.030	19.489	1			
23.48	+/-0.030	23.48	1			
23.67	+/-0.030	23.67	1			
24.11	+/-0.030	24.11	1			
27.46	+/-0.030	27.46	1			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					